

Split - 2

Work Order ID 138439

Tuesday, October 27, 2015 11:28:27 AM

138439

Page 1

Item ID: D2573

Revision ID:

Item Name: Saddle, Aft, Out

Start Date: 10/26/2015

Start Qty: 8.00

8

Required Date: 10/26/2015

Req'd Qty: 8.00

8

Reference:

Accept

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: OCT 29 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2573

F

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.05

HAAS CNC vertical machine #1

Program Batch No.

Double check by:

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

10

10

DAS

44

9-89

16/01/13

16/01/22

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.01

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

10

10

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16/01/13

16/01/22

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Hand Finishing

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[illegible]

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Page 4

Item ID: D2573

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, Out

Start Date: 10/26/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

MLS FEB 04 2016*MLS* FEB 03 2016

Picklist Print

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Page 1

Work Order ID: 138439

138439

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	84.0000	1	8			
D6101-007													
Saddle Billet													

DAS
44
9-89

16/01/13

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT041	54	
134678	14	
136766	40	
MAT043	30	
135939	30	

138056

→ S

136766

→ 11

DART AEROSPACE LTD		Work Order: 138439
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.504	.504	.505	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.572	.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.127	.125	.124	.125		
R	0.240	0.260		.250	.249	.248	.248		
S	0.115	0.135	.124 →	.124	.124	.124	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.237	.239	.238	.238		
W	0.115	0.135		.123	.121	.120	.121		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.249	.248	.248		
AE	1.500	1.520		1.5145	1.513	1.5125	1.5125		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.246	.245	.246		
AI	2.000	2.020		2.005	2.003	2.0025	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

DAS

Measured by: 44	Audited by: 14
Date: 9-99 16/01/13	Date: 9-99 16/02/03

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 138439
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.438	.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.499	.499	0.500		
G	0.257	0.262		.258	.258	.258	0.258		
H	0.375	0.380		.375	.375	.375	0.375		
I	0.490	0.510		.505	.505	.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.572	.572	.560	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.125		
P	0.115	0.135		.130	.130	.135	0.135		
Q	0.115	0.135		.125	.125	.125	0.125		
R	0.240	0.260		.249	.248	.248	0.248		
S	0.115	0.135		.125	.125	.126	0.129		
T	0.178	0.198		.188	.188	.188	0.188		
U	3.210	3.250		3.230	3.230	2.230	3.230		
V	0.230	0.250		.238	.240	.236	0.237		
W	0.115	0.135		.121	.123	.122	0.122		
X	0.308	0.313		.311	.311	0.311	0.311		
Y	0.760	0.765		.760	.760	0.760	0.760		
Z	0.352	0.372		.365	.364	0.363	0.361		
AA	0.470	0.530		.500	.500	.500	0.500		
AB	0.615	0.635		.625	.625	.624	0.624		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.248	.250	.248	0.247		
AE	1.500	1.520		1.5135	1.513	1.5125	1.5125		
AF	0.115	0.135		.125	.125	.135	.135		
AG	0.240	0.280		.260	.260	.272	0.270		
AH	0.240	0.260		.245	.246	.247	0.247		
AI	2.000	2.020		2.004	2.0035	2.003	2.0035		
AJ	0.023	0.043		.033	.033	.033	0.033		
Accept/Reject				✓	✓	✓	✓	DAS	

Measured by: 44	
Date: 14/01/14	

Audited by: 14	
Date: 16/02/03	

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 138435
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	.500	0.500	0.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	0.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	0.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.127	.127	0.125	.127		
R	0.240	0.260		.249	.249	0.248	.250		
S	0.115	0.135		.126	.128	0.127	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.238	.238	0.238	.237		
W	0.115	0.135		.127	.128	0.128	.127		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	.361	0.362	0.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.614	.623	0.614	0.613		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	0.247	.247		
AE	1.500	1.520		1.513	1.512	1.512	1.514		
AF	0.115	0.135		.128	.123	0.127	.127		
AG	0.240	0.280		.270	.260	0.270	.270		
AH	0.240	0.260		.247	.247	0.247	.247		
AI	2.000	2.020		2.004	2.003	2.003	2.005		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

DAS

Measured by:	W.P.
Date:	16/01/19

Audited by:	T4
Date:	9-09/16/02/03

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 138439
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	14	15	16		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.501	0.501	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.569	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.247	0.251	0.248	0.251		
S	0.115	0.135		0.126	0.126	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.238	0.236	0.237		
W	0.115	0.135		0.129	0.128	0.128	0.128		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.361	0.361	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.624	0.623	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.246	0.247		
AE	1.500	1.520		1.512	1.513	1.513	1.513		
AF	0.115	0.135		0.128	0.126	0.127	0.127		
AG	0.240	0.280		0.274	0.275	0.275	0.275		
AH	0.240	0.260		0.247	0.247	0.247	0.247		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject				✓	✓	✓	✓		

Measured by: <i>[Signature]</i>	Audited by: DAS
Date: 16/01/22	Date: 14 09/16/02/03

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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F	13.03.07	Dwg Rev updated	KJ	